

Work Order ID 73320

Wednesday, August 31, 2011 10:52:09 AM

Page 1

Item ID: D3459-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Float Step Mounting Plate

Start Date: 9/1/2011 Start Qty: 16.00

Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 16.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 11-09-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3459

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3459

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B11-9-7

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-9-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DuloskyCount
X22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo *** STOCK IN STEP CELL***	0.00		11-09-07		22	φ		
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

mf
11-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 10:52:06 AM

Page 1

Work Order ID: 73320



Parent Item: D3459-3



Parent Item Name: Float Step Mounting Plate

Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev: A New Issue 06-01-06 JLM
IPP Rev: B waterjet 06-12-06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased		No		110	f	20.0000	0.347	5.844211			



6061-T6 Bar .187 x 4.00

1811-9-7

Location

Loc Qty

Loc Code

MAT001

20

118400

20

118400

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

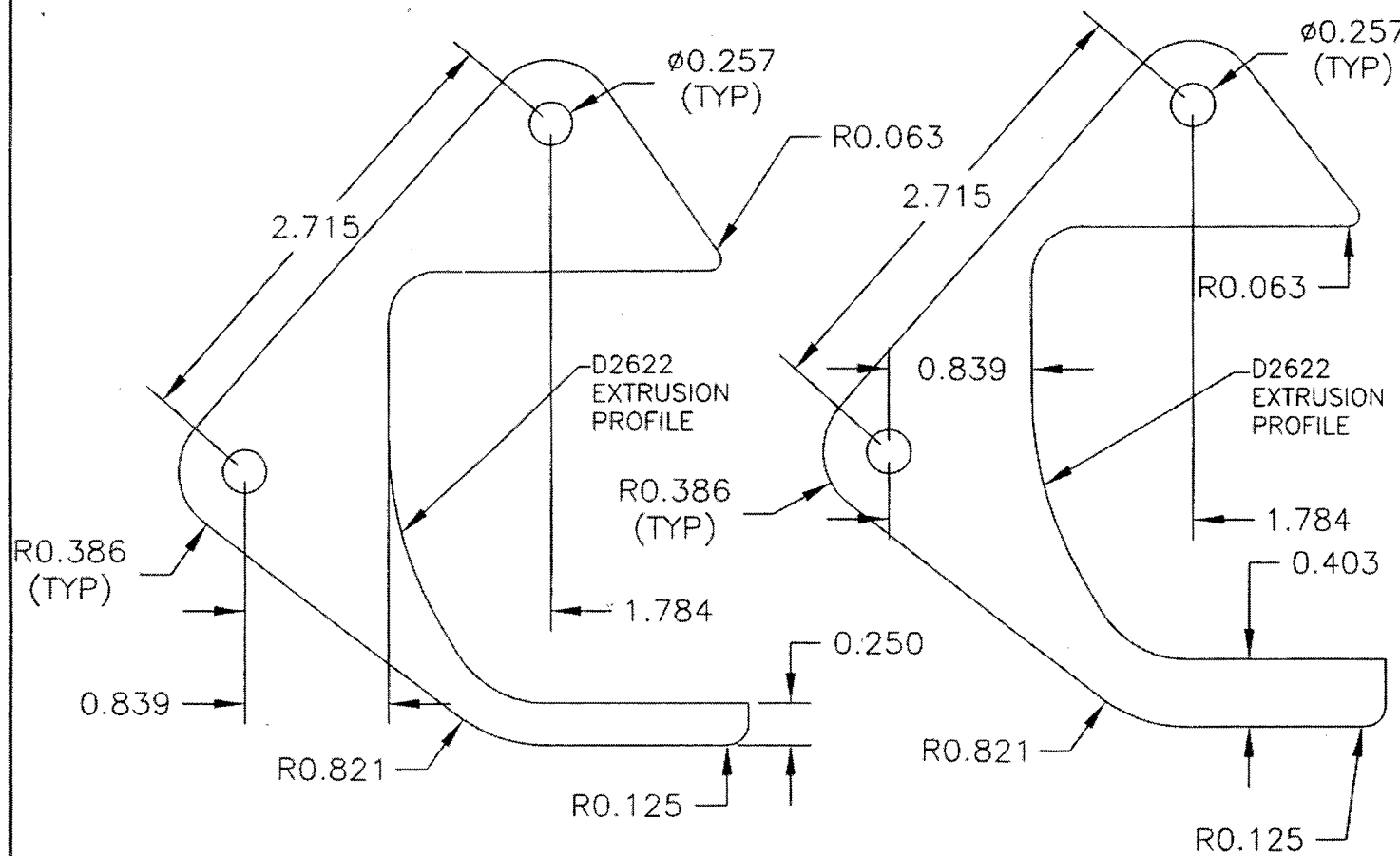
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
PH	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
PH	PH	D3459	
DATE	TITLE	SCALE	
05.09.23	FLOAT STEP MOUNTING PLATE	1:1	
A	05.09.23	NEW ISSUE	



D3459-1 FLOAT STEP MOUNTING PLATE

D3459-3 FLOAT STEP MOUNTING PLATE

D3459-1/-3 FLOAT STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14

73320

W/O:		WORK ORDER CHANGES					
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